



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5627-1

Job Sheet 181808



Part No: D5627-1

Job Qty: 8 ea

Part Name: Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/9/18

Job Tracking No:

Due Date: 8/17/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D5627 REV.B IPP REV:A 18.04.04 NEW ISSUE DD VERF:JFS IPP REV:B 18/08/03 AS PER DWG REV.B
JFS VERF BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	8/17/18	8/17/18	0.00	0.00	Start Up Small Fab-4		
110	Large Fab	8 pcs	8/17/18	8/17/18	0.00	2.00	Large Fab 8		
120	QC	8 pcs	8/17/18	8/17/18	0.00	0.00	QC5		
130	Mill Conv	8 pcs	8/17/18	8/17/18	0.00	1.60	Mill Conv 1		
135	QC	8 pcs	8/17/18	8/17/18	0.00	0.00	QC2 Machining-3		
136	QC	8 pcs	8/17/18	8/17/18	0.00	0.00	QC8 Machining-5		
140	HandFinish	8 pcs	8/17/18	8/17/18	0.00	0.80	HandFinish1		
150	QC	8 pcs	8/17/18	8/17/18	0.00	0.00	QC7-5		
160	Packaging	8 pcs	8/17/18	8/17/18	0.00	0.00	Packaging3-2		
170	QC21-SA	8 Ea	8/17/18	8/17/18	0.00	0.00	QC21		

Part Op 110 - 1- CUT BLANKS at 14.00" 2- BEND AS PER DWG WITH Baileigh Hydraulic CNC Bender using D-1500T-R400-E
Descriptions: Die Set. Bend @ 102 degrees on bender to achieve 90. USE DT _____ AS A TEMPLATE. SCRIBE ENDS FROM THE
EDGE OF TEMPLATE AND CUT TO SIZE.

130 - DRILL HOLES AS PER DWG AND DEBURR

160 - Identify as per dwg & Stock Location: ***GA***

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T1.500W.125	6061T6 Round Tube 1.50 X .125W	9.3600 ft (1.17 ea)	90-Start up Operation	M137623

Job Allocations

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T1.500W.125	6061T6 Round Tube 1.50 X .125W	9.3600 ft (1.17 ea)	90-Start up Operation	M137623



Container No: S108043



Part: D5627 - 1

Job No: 181808

Serial No/Batch: S108043

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Required	Inventory	Allocated
9	49	0

found.

Plex 8/9/18 9:44 AM Dart.lajeunesse.marie

Date: 09/05/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			